Work Orde				*194	1190*							Page	=== ;1
Item ID: Revision ID: Item Name:	D3459-3 Float Step Mo	unting Plate		Accept	*N900	<u>ი</u> 40	100)* ፡	Setup S	tart Stop	*N!	S1*	
Start Date: Required Date: Reference:	9/10/14 9/10/14	Start Qty: 12,00 Req'd Qty: 12,00	*1 <i>9</i> * *1 <i>9</i> *	·	Cust Item I Customer:	D:							
Approvals:	Process Pla	n: _MCJ	Date: 14-09-17	Tooling: SPC (Y/N):		ate:		I		tart Stop		R1* R2*	
Sequence ID/ Work Center II	D	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty		Reject Number	Insp. Stamp	
Draw Nbr	Rev	ision Nbr						***************************************					
D3459	Rev	A											
*100		FLOW WATER JET		0.00				20		.		DAS 23 9-89	14-69-
Waterjet FLOW CNC Waterj	et	Memo 1-Cut as per Dwg Rev: Prog Rev: 2-Deburr if n	A	0.00									
			ES ARE PROGRAMMED Y ON DRILL PRESS	SMALER,OPEN TO .2	57"								
*110 *11 0 *		QC2- Inspect parts off ma	achine FAI/FAIB	0.00				2 0	_			DAS 23 9-89	14-10-2
QC		Memo		0.00				20	5				14-10.5

Memo

Quality Control

DQA:			Date:											
						WORK ORDER NON	-CC	ONFO	RMANCE / UF				_	AEROSPACE
QA Closed:		¥.	Date:				-			W	ork Order up	date only		
Work Orde	ır.					DISPOSITION				AGAINST DE	PARTMENT	PROCESS		
Work Orac	•					Rework	1		Skid-tube	Crosstube]	Water Jet	\neg	Engineering
Part N	lo.					Scrap	1 1		Machining	Small Fab	Pro	d. Eng. Coor.	ヿ	Quality
	•					Use-as-is	1		noforming	Finishing	4	e/Packaging		Other
NCR N	lo.					Suspected Unapproved]		Large Fab	Composite]	Supplier		
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Root		Date	Step	Qty	Desci	ription of work order update or non-conformance	1	niciai ief Eng	Descri		Date	Verification	,	QC Inspector
Cause Design	\dashv	Date	Step	Qty		or non-comormance	1	ilei Liig	Descri	ption	Dute	Vermedioi	计	QC IIISPECTOI
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Offset/Setup													ı	
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Supplier													İ	
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							FA	ULT CA	TEGORY					
Landi		1			_	General		11:-/5) wa awa wa		Outside Dim	onsions [Pressure/Forced
		Bending	ot Concer		-	Bend BOM/Route	-	Grain	Program	-	Over/Under	ŀ		Set-up
		Cracks	or concer	ILTIC		Broken/Damage/Defect	\vdash	Hardwa	aro.		Part Incorre			Temperature/Cure
		Crimp/Ki	nk/Rinnle	/\ <i>M</i> ave		Burrs	\vdash	4	ion Incomplete/Un	ogualified —	Part Lost/Mi	· · · · · · · · · · · · · · · · · · ·		Weld
	\vdash	Cuffs	πητιρρίο	, wave		Contamination	\vdash	1	tions Incomplete/L	· -	Part Moved	336	_	Wrong Stock Pulled
;		Crushing			 	Countersink	-	4	gned/off center	-	Positioned V	ا Vrong		g
	<u> </u>	Heat Tre			-	Cut Too Short		Mislabe			Power Loss/		\Box	Other
		1	n Strip in	Tube	F	Drawing		Misrea		L	_	- (
	Г	Marks/Cl				Drill Holes		Off-set						
1		4	Sequence			Finish		Out of	Calibration					
		Wave/Tv	vist in Tuk	ре		Fit/Function		Out of	Sequence					

Work Ord September-11-1				*124				Page 2			
Item ID: Revision ID: Item Name: Start Date: Required Date Reference:	D3459-3 Float Step M 9/10/14 : 9/10/14	ounting Plate Start Qty: 12.00 Req'd Qty: 12.00	*1 <i>2</i> *1 <i>2</i>		*N900 Cust Item I Customer:		100)*	Setup Sta	IV	S1* S2*
Approvals:	Process Pl	an:	Date:	Tooling: SPC (Y/N):		ate:		I	Run Sta Sto	/\\ q	R1* R2*
Sequence ID/ Work Center I 120 *1 20* QC Quality Control	D	Operation Description QC8- Inspect parts - seco	nd check	Set Up/ Run Hours 0.00	Tool ID	Tool#	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp DAS 38 9-89 14-10-2
130 *120* Packaging Packaging		Identify as per dwg & Sto Memo *** STOCK	ock Location: WAO	0.00				_20_	(4.	10-02	DMC

0.00

0.00

QC21- Final Inspection - Work Order Release

Memo

140

140

Quality Control

MW 14-10-03

DQA:			Date:										•	
						WORK ORDER NON	-CC	ONFO	RMANCE / UF			_	_	AEROSPACE
QA Closed:			Date:							V	ork Order up	odate only		
Work Orde	or.					DISPOSITION				AGAINST D	EPARTMENT	/PROCESS		
Work Orac	•					Rework]		Skid-tube	Crosstube		Water Jet	٦	Engineering
Part N	۱o.				i	Scrap			Machining	Small Fab	Pro	d. Eng. Coor.		Quality
	•					Use-as-is		Thern	noforming	Finishing	Rec/Sto	re/Packaging		Other
NCR I	۱o.					Suspected Unapproved]		Large Fab	Composite		Supplier		
Root			i ''''		Desc	ription of work order update		nitial	Acti	ion	Sign &		T	
Cause		Date	Step	Qty		or non-conformance	1	ief Eng	Descr		Date	Verification		QC Inspector
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Equip/Tooling				·									İ	
Handling/Pre]											
Material														
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Training		i		 								1	1	
Transport													١	
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							FA	ULT CA	TEGORY					
Landi	ng (Gear				General	_	_			_	_	_,	
		Bending				Bend	_	Folio/F	Program	_	Outside Dim	ensions		Pressure/Forced
		Centre N	ot Concer	ntric		BOM/Route		Grain		<u>L</u>	Over/Under	tolerance		Set-up
		Cracks				Broken/Damage/Defect	L	Hardwa		<u>_</u>	Part Incorre	}	_	Temperature/Cure
		Crimp/Kii	nk/Ripple	/Wave		Burrs		Inspect	ion Incomplete/Ur	nqualified	Part Lost/M	issing	\dashv	Weld
		Cuffs				Contamination		4	tions Incomplete/L	Jnclear	Part Moved	L		Wrong Stock Pulled
		Crushing				Countersink		Misali	gned/off center		Positioned V		_	
		Heat Trea	at			Cut Too Short		Mislab	eled		Power Loss/	Surge	(Other
		Inspectio	n Strip in	Tube		Drawing		Misrea	d					
		Marks/Cl	natter			Drill Holes		Off-set						*********
ł		Turning S	equence			Finish		Out of	Calibration					
]		Wave/Tw	vist in Tub	эе		Fit/Function		Out of	Sequence					

Picklist Print

September-11-14 11:58:00 AM

Work Order ID: 124190

124190

Parent Item:

D3459-3

D3459-3

Parent Item Name: Float Step Mounting Plate

Start Date: 9/10/14

Required Date: 9/10/14

Start Qty: 12.00

Required Qty: 12.00

Comments:

New Issue 06-01-06 JLM IPP Rev: A IPP Rev: B

waterjet 06-12-06 ec

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Primary Item Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B0.187X04.00 0		Purchased	No		110	f	58.0168	0.347	3		DAS 23	
M6061T6	SB0 187	X04 00)O					**			9-89	17.1-45

6061-T6 Bar .187 x 4.00

Location Loc Qty Loc Code MAT051 58.016842 m128265 16.116842 12944 m129411 41.9

Page 1

DQA:		_ Date:											$\mathbb{G}^{Z'}$	ART
QA Closed:		Date:			WORK ORDER NON-	-CC	ONFO	RMANCE / UI		Wo	rk Order up	odate only	7	EROSPACE
					DISPOSITION				AGAINST	DEP	ARTMENT	/PROCESS	<u> </u>	
Work Orde	r:								1			\4/a4aa.1a4	٦	
Part N	o			_	Rework Scrap Use-as-is			Skid-tube Machining noforming	Crosstube Small Fab Finishing	\exists		Water Jet d. Eng. Coor. re/Packaging] a	eering Quality Other
NCR N	o		······································		Suspected Unapproved		111611	Large Fab	Composite			Supplier	<u> </u>	
Root		1		Desci	ription of work order update	I	nitial	Act	ion		Sign &			
Cause	Date	Step	Qty		or non-conformance	Ch	ief Eng	Descr	ription		Date	Verification	QCI	nspector
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Offset/Setup						İ								
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Unapproved			1											
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Landir	ng Gear				General		· · ·		· -					
	Bending				Bend		Folio/I	Program			Outside Dim	ensions	Pressure	e/Forced
•	Centre f	Not Conce	ntric		BOM/Route	Г	Grain				Over/Under	tolerance	Set-up	
	Cracks				Broken/Damage/Defect		Hardwa	are			Part Incorre	cí 🗌	Tempera	ature/Cure
Ī	Crimp/K	ink/Ripple	e/Wave		Burrs	Г	Inspect	ion Incomplete/U	nqualified		Part Lost/Mi	issing	Weld	
	Cuffs				Contamination		Instruc	tions Incomplete/l	Unclear		Part Moved		Wrong S	tock Pulled
ľ	Crushin	3			Countersink		4	gned/off center			Positioned V	Vrong	_	
	Heat Tre				Cut Too Short		Mislab				Power Loss/	Surge	Other	
	 	on Strip ir	n Tube		Drawing		Misrea	d	!			_		
	Marks/0	•			Drill Holes		Off-set			•				
		Sequence	9		Finish		-	Calibration		•				·
	_	wist in Tu			Fit/Function		Out of	Sequence						

DART AEROSPACE LTD	Work Order:	124190
Description: Float Step Mounting Plate	Part Number:	D3459-3
Inspection Dwg: D3459 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Art	ticle	Prototype
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Drawing	Tolerance	Actual	Accept	Reject	Method of Inspection	Comments
Dimension	118	Dimension			mispection	
Ø0.257	+0.006/-0.001	0.257	į		v	Thomas
2.715	+/-0.010	2718	1		V	
0.403	+/-0.010	0.403			V	
R0.125	+/-0.010	0.125	1		Ro	
R0.063	+/-0.010	0.063	-		20	
0.839	+/-0.010	0.539	-		U.	
0.188	+/-0.010	O.189~			J	
			-			
9.40.						
	,					
	DAS		DAS			
	22		UA3	L		

Rev	Date	Change	Revised by	Approved
Α	07.01.17	New Issue	KJ/JLM	
В	07.09.06	Dimensions added	KJ/JLM ox	6
			7 ()	

